

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-006163**Date Inspected:** 10-Apr-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1830**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 630**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Guo Peng and Chen Xi**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower and OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Joe Alaniz was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

Bay 13

This QA inspector performed UT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The member(s) is/are identified as 1BW Corner Assembly and 1BW diaphragm. The weld designations reviewed are as follows:

1. CSD7-PP12-081, 083, 085, 093, 101 and 113.
2. FB059-002-016 and 026.
3. FB059-003-016 and 026.

Bay 11

This QA Inspector observed the following work in progress:

SAW welding of weld joint 23(24) and 21 located on PCMK WSD1-FESA3-2A/D.

Welder is identified as Mr. Qin Xiulax (044550). ZPMC QC is identified as Guo Peng.

The welding variables recorded by QC appeared to comply with WPS-B-P-2321-B-P3-S-2.

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SMAW welding of weld joint 10 (11) located on PCMK FDSA3-2B/C-10.

Welder is identified as Mr. Wang Jintao (205678). ZPMC QC is identified as Guo Peng.

The welding variables recorded by QC appeared to comply with WPS-B-T-2211-B-U3b.

Bay 10

This QA Inspector observed the following work in progress:

SMAW welding of weld joint 3C located on PCMK SSD1-A164A/J.

Welder is identified as Mr. Fang Kaiyuan (040267). ZPMC QC is identified as Jin Dong Liang.

The welding variables recorded by QC appeared to comply with WPS-345-SMAW-2G (2F).

Bay 3

SAW welding of weld joint 002 located on PCMK FB005-043.

Welder is identified as Mrs. Huang Xinlan (044780). ZPMC QC is identified as Chen Xi.

The welding variables recorded by QC appeared to comply with WPS-B-T-2221- B-L2c-S-2.

SMAW welding of weld joint 056-053 located on PCMK FB027-028.

Welder is identified as Mr. Liu Ming (044790). ZPMC QC is identified as Chen Xi.

The welding variables recorded by QC appeared to comply with WPS-B-T-2232-Tc-U4b-F.

Bay 6

FCAW welding of weld joint 18, 26, 27 and 36 located on PCMK WDI-CBSA3-1-2.

Welder is identified as Mr. Li Shuliang (048801). ZPMC QC is identified as Liu Huanjie.

The welding variables recorded by QC appeared to comply with WPS-B-T-2332-Tc-P4-F-1.

FCAW welding of weld joint 28, 34, 48 ad 50 located on PCMK WD1-CBSA3-1-2.

Welder is identified as Mr. Guo Tiyong (205386). ZPMC QC is identified as Liu Huanjie.

The welding variables recorded by QC appeared to comply with WPS-B-T-2332-Tc-P4-F-1.

Bay 7

FCAW welding of weld joint 002~005 located on PCMK SP664-001.

Welder is identified as Mr. Chen Ning (054456). ZPMC QC is identified as Xu Xia Ping.

The welding variables recorded by QC appeared to comply with WPS-B-2112-FCM.

FCAW welding of weld joint 006~009 located on PCMK SP664-007.

Welder is identified as Mr. Jia Anquan (201725). ZPMC QC is identified as Xu Xia Ping.

The welding variables recorded by QC appeared to comply with WPS-B-2112-FCM.

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Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (134-8257-0045), who represents the Office of Structural Materials for your project.

Inspected By:	Alaniz, Joe	Quality Assurance Inspector
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Reviewed By:	Carreon, Albert	QA Reviewer
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